



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
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Tel (613) 632-5200
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PTO

20-8304
D3156-1
Job Sheet 211918



Part No: D3156-1
Part Name: Bracket


Part Weight: 0 lbs
Job Created: 7/31/20
Due Date: 8/4/20
Type: SOLD

Job Qty: 2 pcs

Status: New

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG REV B IPP A 04.11.30 New issue KJ/JLM

Ship Via:

POSITIVE RECALL

EFFECTIVE 2/27/21 **AUTH** SM

RELEASED 10 **DATE** 20.8.6 **Priority:** Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	2 pcs		8/3/20	0.17	0.08	Waterjet - Flow		on 20/07/31
130	QC 8	2 pcs		8/3/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
							QC 8 - 73		
							QC 8 - 82		
150	Small Fab - Brake NC - B4B	2 pcs		8/3/20	0.25	0.03	Small Fab - Brake - 1 - B4B		

DAS
AUG 05 2020 40
#88

PTO

160 QC 5	2 pcs	8/3/20	0.00 0.00	Small Fab - Brake - 2 - B4B	AUG 06 2020
				Small Fab - Brake - 3 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
170 Handfinish - 1-1 Chemical-B4B	2 pcs	8/4/20	0.00 0.09	Handfinish - 1 - 1 - B4B	AUG 08 2020
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
180 QC 7	2 pcs	8/4/20	0.00 0.00	QC 7 - 10	2020/08/06
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	



See Rat. D
for sign off of Positive Recall
and give to Eng "Spec. D"

190	Packaging 3-1 - Stock - B4B	2 pcs	8/4/20	0.00 0.00	QC 7 - 47	
					QC 7 - 48	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
Packaging 3 - 26 - B4B						
Packaging 3 - 37 - B4B						
200	QC 21 - SA	2 pcs	8/4/20	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 9	9-89
					QC 21 - SA - 77	
						AUG 06 2020

Part Op 110 - Cut as per dwg D3156 Prog rev: B Dwg rev: B Deburr as required
Descriptions: 130 - QC8- Inspect parts - second check
150 - Form as per Dwg D3156
160 - QC5- Inspect part completeness to step on W/O
170 - Chemical Conversion Coat per QSI005 4.1
180 - QC7-Inspect Chemical Conversion Coat
190 - Identify as per dwg & Stock Location:
200 - QC21- Final Inspection - Work Order Release

200731

Job BOM

Job BOM records could not be found.

M2024T3S.050

SF.009EACH

5237392

Job Allocations

Job Allocations could not be found.

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.067inches + 0.004 - 0.001	0.071 0.066		
2	Bracket	0.098inches ± 0.030	0.128 0.068		
3	Bracket	0.250inches ± 0.010	0.260 0.240		
4	Bracket	0.325inches ± 0.010	0.335 0.315		
5	Bracket	0.230inches ± 0.010	0.240 0.220		
6	Bracket	0.850inches ± 0.010	0.860 0.840		
7	Bracket	1.881inches ± 0.010	1.891 1.871		
8	Bracket	0.650inches ± 0.010	0.660 0.640		

Plex 7/31/20 9:45 AM dart.lacelle.linda



Container No: S291349



Part: D3156-1

Job No: 211918

Serial No/Batch: S291349

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/31/20

Entered: LR Date: Aug 18/2020



NCR No. 20-83040

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>211918</u> Part No. <u>D3156-1</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
Date: <u>AUG 04 2020</u>		Sequence #: <u>110</u>		QTY Affected: <u>2 of 2</u>		MRB (Q51042) <u>SMY</u> <u>20/07/21</u>																													
Description Work Order Deviation <u>Omit 2 0.098 holes Qty 2 per D3156-1 Rev. B</u> <u>Leave 0.067 holes</u>				Disposition <u>Acceptable for space down deviation</u>		Completed By <u>DC 24/08/04</u>																													
						Lead hand / Supervisor DAS <u>55</u> 9-89 <u>AUG 06 2020</u>																													
						QC / QA Coordinator DAS <u>55</u> 9-89 <u>AUG 06 2020</u>																													
Root Cause Operator ☒ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☒ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☒ Fit/Function	☐ Off-set/Set-up	
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